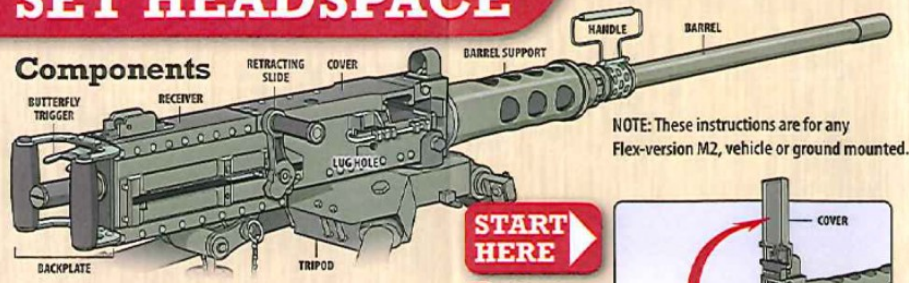
SET HEADSPACE

Components



NOTE: These instructions are for any Flex-version M2, vehicle or ground mounted.

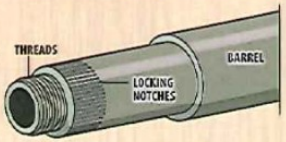
WARNINGS

- Clear weapon each time you check weapon.

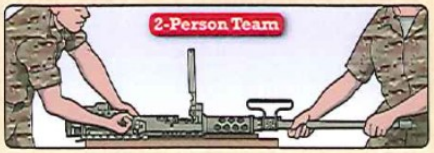
- Failure to properly set Headspace can result in an explosion and possibly cause injury or death.
- Always set Headspace first and Timing second.

REMEMBER — Headspace and Timing should be checked and adjusted before firing weapon, after assembling weapon and after replacing barrel.

Before inserting Barrel, inspect Threads and Locking Notches for dents and nicks.

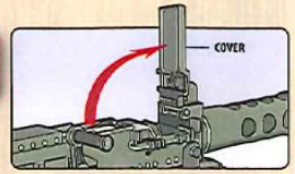


Headspace and Timing can be set by 1 person or a 2-person team.

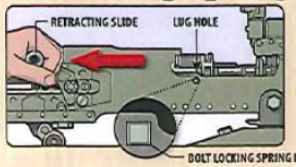


START HERE

1 Raise Cover



2 Align Bolt and Bolt Locking Spring Lug



Pull Retracting Slide back until Bolt Locking Spring Lug can be seen through Lug Hole.

3 Attach Barrel

Hold Retracting Slide in position and screw Barrel CLOCKWISE until it stops.

4 Check Barrel

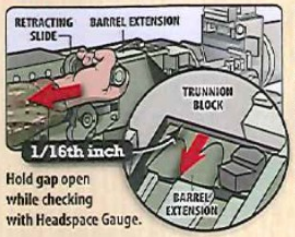
Screw Barrel COUNTER-CLOCKWISE—2 CLICKS. Release Retracting Slide. Test: Twist Barrel back and forth; it should NOT rotate.

5 Charge Weapon

Release Retracting Slide—DO NOT SLAM.

RETRACTING SLIDE
Pull Retracting Slide all the way back.
When Retracting Slide recoils guide it back without letting it slam hard.
RETRACTING SLIDE

6 Retract Slide and Hold

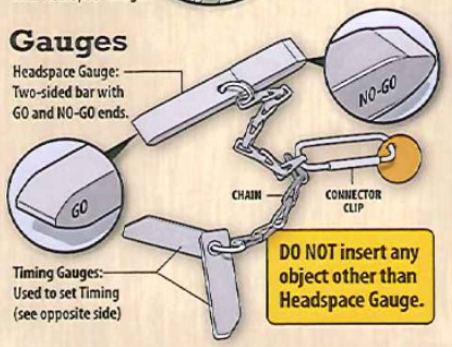


Pull Retracting Slide back until Barrel Extension moves slightly.

Do not allow gap between Barrel Extension and Trunnion Block to be more than 1/16th inch.

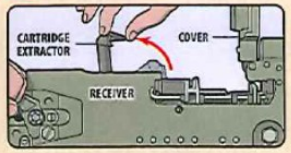
Hold gap open while checking with Headspace Gauge.

Gauges

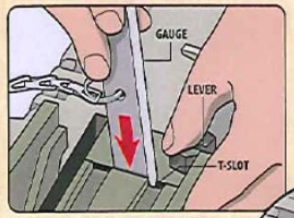


DO NOT insert any object other than Headspace Gauge.

7 Check Go Gauge



Raise Cartridge Extractor up. It is the long, claw-like lever on left side.



Push Lever next to T-Slot to the side.

Insert GO end of Headspace Gauge into T-Slot at end of Barrel Extension.

If GO end of the Gauge DOES NOT insert all the way to Ring, Barrel is TOO TIGHT.

You must adjust the Barrel. (Go to STEP 9)

If GO end DOES insert all the way to Ring, go to STEP 8.

8 Check No-Go Gauge

Insert NO-GO end of Headspace Gauge into T-Slot.

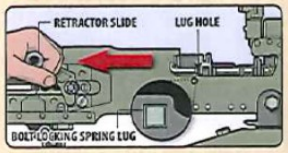
If NO-GO end of the Gauge DOES insert, Barrel is TOO LOOSE.

You must adjust the Barrel. (Go to STEP 9)

If you CANNOT insert NO-GO end: HEADSPACE IS SET.

Go to TIMING

9 Adjusting Headspace



Pull Retracting Slide back until Bolt Locking Spring Lug is aligned in Lug Hole. Hold Retracting Slide in this position while adjusting the Barrel.

Choose an adjustment based on gauge check.

Too Tight

Turn Barrel COUNTER-CLOCKWISE 1 CLICK.

Too Loose

Turn Barrel CLOCKWISE 1 CLICK.

DO NOT turn Barrel more than 1 CLICK.

10 Recheck Gauges

After each CLICK in STEP 9, REPEAT STEPS 7 & 8.

11 Repeat Until...

...GO end of Gauge fully inserts and NO-GO end does not. HEADSPACE IS SET.

Go to TIMING

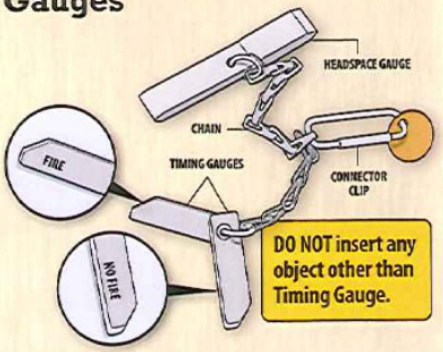
REMEMBER — DO NOT USE Barrel that has been turned COUNTER-CLOCKWISE more than a total of 7 times, including the intial 2 CLICKS in STEP 4.

SET TIMING

WARNINGS

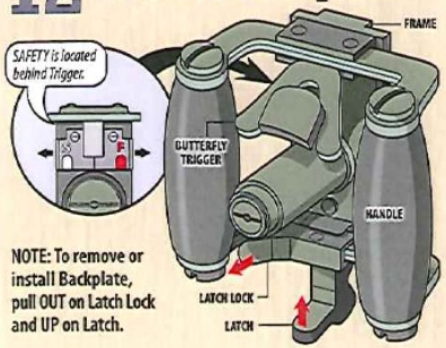
- Clear weapon each time you check weapon.
- Always set Headspace first and Timing second.
- Set Safety to "F" position before you begin.

Gauges

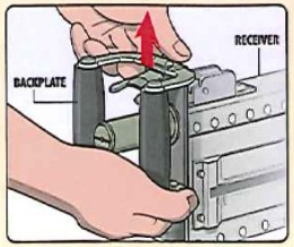


DO NOT insert any object other than Timing Gauge.

12 Remove Backplate



NOTE: To remove or install Backplate, pull OUT on Latch Lock and UP on Latch.

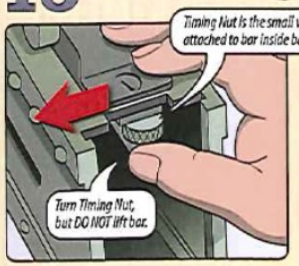


Stand to one side of gun, NOT behind it.

Remove Backplate by pulling OUT on Latch Lock and UP on Latch.

Slide Backplate straight up to remove.

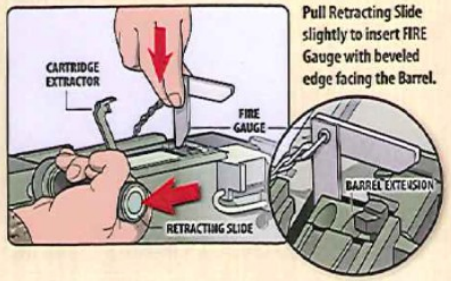
13 Turn Timing Nut



Turn Timing Nut all the way to the LEFT, but DO NOT loosen completely.

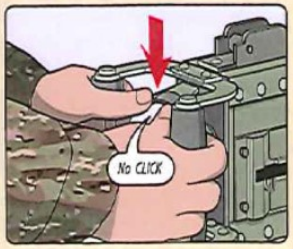
Reinstall Backplate.

14 Insert Fire Gauge



Pull Retracting Slide slightly to insert FIRE Gauge with beveled edge facing the Barrel.

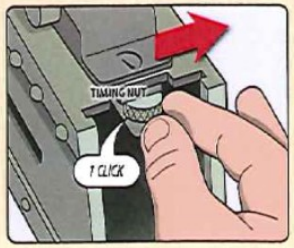
15 Attempt to Fire



Ensure SAFETY is in "F" position. (See STEP 12)

Attempt to fire by depressing Butterfly Trigger. Gun should not fire because firing pin has not released.

16 Turn Timing Nut



Remove FIRE Gauge. Standing to one side, remove Backplate again and turn Timing Nut 1 CLICK to the RIGHT.

17 Repeat Sequence

Reinstall Backplate. Reinsert FIRE Gauge. Attempt to fire by depressing Butterfly Trigger.

Repeat steps 16 & 17 until gun fires.

18 Add Two Clicks

Once gun fires, remove FIRE Gauge and Backplate, then turn Timing Nut 2 MORE CLICKS to the RIGHT.

19 Charge Weapon

Reinstall Backplate and lower Extractor to prevent damaging weapon. Charge Weapon and allow Retracting Slide to go forward—DO NOT SLAM.

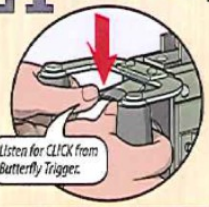
20 Attempt to Fire

Pull Retracting Slide slightly to insert NO FIRE Gauge with beveled edge against Barrel.

Attempt to fire by depressing Butterfly Trigger. (See STEP 15)

Gun should not fire.

21 Fire Weapon



Remove NO FIRE Gauge and reinsert FIRE Gauge.

Attempt to fire by depressing Butterfly Trigger.

Gun should fire.

Repeat steps 19–21 to ensure TIMING IS SET correctly.

Headspace and Timing should be checked and adjusted before firing weapon, after assembling weapon and after replacing barrel.

Kwikpoint

M2 .50 CAL

HEADSPACE & TIMING

Visual User Guide

All instructions, graphics and text in this guide were approved by PEO Soldier, U.S. Army. http://peosoldier.army.mil

WARNINGS

- Clear weapon each time you check weapon.
- Always set Headspace first and Timing second.
- DO NOT use coins, dog tags or links in place of Gauges issued with weapon.

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